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D3043-041
Job Sheet 182491



Part No: D3043-041

Job Qty: 2 ea

Part Name: Step Weldment LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/14/18	0.00	0.00	Start Up Large Fab-4		CC
100	Large Fab	2 pcs		9/14/18	0.00	2.64	Large Fab 8		CC
110	QC	2 pcs		9/14/18	0.00	0.00	QC6		CC
120	Large Fab	2 pcs		9/14/18	0.00	2.64	Large Fab 8		CC
130	QC	2 pcs		9/14/18	0.00	0.00	QC9		CC
140	QC	2 pcs		9/14/18	0.00	0.00	QC5		CC
150	HandFinish	2 pcs		9/14/18	0.00	0.50	HandFinish1		D.R. 18/09/18
160	Large Fab	2 pcs		9/14/18	0.00	2.64	Large Fab 8		CC
170	QC	2 pcs		9/14/18	0.00	0.00	QC10		CC
180	QC	2 pcs		9/14/18	0.00	0.00	QC5		CC
200	HandFinish	2 pcs		9/14/18	0.00	0.50	HandFinish6		CC
210	Powdercoat	2 pcs		9/14/18	0.00	0.58	Powdercoat1		CC
220	HandFinish	2 pcs		9/14/18	0.00	0.50	HandFinish3		CC
230	QC	2 pcs		9/14/18	0.00	0.00	QC3		CC
240	Packaging	2 pcs		9/14/18	0.00	0.00	Packaging3-1		CC
250	QC21-SA	2 Ea		9/14/18	0.00	0.00	QC21		CC

Part Op 100 - 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Deburr and Descriptions: bevel ends for welding

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 AR AL ROD

Batch: _____ 2-Grind Fwd End Cap weld flush

160 - 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: _____ 2-Inspect for foreign object

as per QSI 024 3-Grind Fwd End Cap weld flush

210 - START TIME: 2:00 OVEN TEMPERATURE: 320° FINISH TIME: 2:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5104007
D3040-3	Mounting Lug	4 Ea (2 ea)	90-Start up Operation	5128957
D2734	Step End Plate	2 Ea (1 ea)	120-Large Fab	5077383
D3040-1	Mounting Lug	4 Ea (2 ea)	120-Large Fab	5001878
D2734	Step End Plate	2 Ea (1 ea)	160-Large Fab	

Job Allocations

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	209	0
	D3040-3	4	18	0
120-Large Fab	D2734	2	70	0
	D3040-1	4	12	0
160-Large Fab	D2734	2	70	0
Part Specifications				
Specifications could not be found.				

Plex 8/24/18 2:22 PM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework Scrap Use-as-is Suspected Unapproved	AGAINST DEPARTMENT Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite
Date :	Step #:	QTY Effective :

Description Work Order Deviation	Disposition

Root Cause			FAULT CATEGORY			
Environment		No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design		Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data		Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling		Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre		Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material		Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport		Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge		Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA		Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation		Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date		Manufacturing Process				
Misidentified		Past Due	OTHER :			

Part: D3043-041
Job No: 182491
Serial No/Batch: S108477
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 09/07/16

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Approval